

**CLAIMS**

1. A method for producing plastic profiles, in which a first profile is initially produced by extruding a profiled bar (6) through an extruder (2) and molding said profiled bar in a first extrusion die nozzle (3a) that is connected to the extruder (2), whereupon the profiled bar is calibrated in a first calibrating die (4a) arranged on a calibrating table (5) and is chilled, whereupon the first extrusion die nozzle (3a) is separated from the extruder (2) and a second extrusion die nozzle (3b) is attached to the extruder (2) and/or the first calibrating die (4a) is removed from the calibrating table (5) and a second calibrating die (4b) is attached in order to produce thereafter a second profile, characterized in that prior to severing the first extrusion die nozzle (3a) the second extrusion die nozzle (3b) is made available on a freely movable first manipulating device (9) in the region of the extruder (2), whereupon the first extrusion die nozzle (3a) is removed from the extruder (2) by a nozzle lifting apparatus (10, 11) of the first manipulating device (9) and the second extrusion die nozzle (3b) is brought to the extruder (2) to the docking position by the nozzle lifting apparatus (10, 11) and/or that prior to the dismounting of the first calibrating die (4a) the second calibrating die (4b) is made available in the region of the calibrating table (5) on a freely movable second manipulating device (18), whereupon the first calibrating die (4a) is removed from the calibrating table (5) by a calibrating die lifting device (16, 17) of the second manipulating device (18) preferably transversally to the direction of extrusion (12), and the second calibrating die (4b) is brought to the calibrating table (5) to the docking position by a calibrating die lifting apparatus (16, 17) preferably transversally to the direction of extrusion (12).
2. A method according to claim 1, characterized in that the first extrusion die nozzle (3a) is removed from the extruder (2) by a first nozzle lifting apparatus (10) of the first manipulating device (9) and the second extrusion die nozzle (3b) is brought to the extruder (2) to the docking position by a second nozzle lifting apparatus (11) of the first manipulating device (9).

3. A method according to one of the claims 1 or 2, characterized in that the second extrusion die nozzle (3b) is preheated on the first manipulating device (9).
4. A method according to one of the claims 1 to 3, characterized in that the first calibrating die (4a) is removed from the calibrating table (5) by a first calibrating die lifting apparatus (16) of the second manipulating device (18) and the second calibrating die (4b) is brought to the calibrating table (5) to the docking position by a second calibrating die lifting apparatus (17) of the second manipulating device (18).
5. A method according to one of the claims 1 to 4, cooling water and/or vacuum supply lines (7, ) being connected to the calibrating die (4) attached to the calibrating table (5), characterized in that upon removing the first calibrating die (4a) from the calibrating table (5) cooling water and/or vacuum supply lines (7, 8) are severed automatically from the first calibrating die (4a) and, after transferring the second calibrating die (4b) to the calibrating table (5) to the docking position, are connected automatically to the second calibrating die (4b).
6. A method according to one of the claims 1 to 5, characterized in that the removal of the first calibrating die (4a) from and the transfer of the second calibrating die (4b) to the calibrating table (5) occurs from the same longitudinal side of the calibrating table (5).
7. A method according to one of the claims 1 to 5, characterized in that the removal of the first calibrating die (4a) from and the transfer of the second calibrating die (4b) to the calibrating table (5) occurs from different longitudinal sides of the calibrating table (5).
8. An apparatus for manipulating extrusion die nozzles (3; 3a, 3b) which is configured as a movable first manipulating device (9), comprising at least one nozzle lifting apparatus (10, 11) for receiving extrusion die nozzles (3; 3a, 3b).

9. An apparatus according to claim 8, characterized in that lifting apparatus (10, 11) for the extrusion die nozzle comprises a first lifting arm (10a) for receiving a first extrusion die nozzle (3a) and a second lifting arm (11a) for receiving a second extrusion die nozzle (3b).
10. An apparatus according to claim 9, characterized in that the first and second lifting arm (10a, 11a) are movable independent from each other.
11. An apparatus according to one of the claims 8 to 10, characterized in that a heating apparatus for at least one extrusion die nozzle (3; 3a, 3b) is provided.
12. An apparatus for manipulating calibrating dies (4; 4a, 4b), configured as a movable second manipulating device (18), comprising at least one calibrating die lifting apparatus (16, 17) for receiving calibrating dies (4; 4a, 4b).
13. An apparatus according to claim 12, characterized in that the second manipulating device (18) comprises at least one displacement unit (19, 20), preferably with roller or slide bearing, for the calibrating die (4; 4a, 4b).
14. An apparatus according to claim 12 or 13, characterized in that the calibrating die lifting apparatus (16, 17) comprises a first lifting arm (16a) for receiving a first calibrating die (4a) and a second lifting arm (17a) for receiving a second calibrating die (4b).
15. An apparatus according to claim 14, characterized in that the first and the second lifting arm (16a, 17a) of the calibrating die lifting apparatus (16, 17) can be moved independent from each other.
16. An apparatus according to one of the claims 12 to 15, characterized in that the second manipulating device (18) can be docked and fixed to the calibrating table (5).
17. An apparatus according to one of the claims 12 to 16, characterized in that the calibrating die (4; 4a, 4b) can be connected to cooling water and/or

vacuum supply lines (7, 8) of the calibrating table (5) by way of an automatic coupling unit (28).

18. An apparatus according to one of the claims 12 to 17, characterized in that the second manipulating device (18) is provided with only one lifting device and the changing process is supported by a transversal displacement unit (30).
19. An apparatus according to one of the claims 12 to 18, characterized in that the transversal displacement unit (30) is arranged between the calibrating die (4) and the mounting frame (27) of the calibrating table (5) and the calibrating die (4) rests on the transversal displacement unit (30) by vertical lowering of the mounting frame (27) and the cooling water and vacuum supply lines (7, 8) are severed as a result.
20. An apparatus according to one of the claims 8 to 17, characterized in that the first and/or second manipulating device (9, 18) is provided with an automotive configuration.